

Work Order ID 59534

June 7, 2010 10:33:53 AM



Page 1

Item ID: D206-547-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Console High Slope

Start Date: 6/07/10 Start Qty: 5.00



Cust Item ID:

Required Date: 6/11/10 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D206-547

Rev F

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4 2-Deburr

ES 10/06/17 (5)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Grind weld relief chamfer as per Dwg D206-547 2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

ES 10/06/18 (5)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/06/18

(+5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/11/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Tack weld as per Dwg D206-547 A/R
Batch: M111385

AL ROD

EL 10-6-21

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/06/21



150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 10/06/21



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/11/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

Signature 6/10/22 (5)

170

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

Signature 6/10/22

(X5)

180

0.00



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Powdercoat

Memo

Powder Coating

START TIME:

1:35

OVEN TEMPERATURE:

FINISH TIME:

2:05

Signature 6/10/22

Signature 6/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59534

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Item ID: D206-547-043

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Item Name: Console High Slope

Start Date: 6/07/10 Start Qty: 5.00



Cust Item ID:

Required Date: 6/11/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MA 10 06 22 (5)

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PP 59785

10-6-23 SL (5)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23 J

W 10-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 59534

Parent Item: D206-547-043

Parent Item Name: Console High Slope






Comments: IPP Rev: 06-01-05 Removed Packing Kit JLM

Start Date: 6/07/10

Required Date: 6/11/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2024  Console Extrusion		Manufactured	No			110	f	1,183.000	3.42	18		6/10/06/18 M01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT06				1183					
								1183					
D2602-1  Console Side, 206 Console		Manufactured	No			110	Each	0.0000	1	5		6/10/06/18	
D2602-2  Console Side, 206 Console		Manufactured	No			110	Each	3.0000	1	5		6/10/06/18	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST177				2					
				52697				2					
				ST178				1					
				46249				1					
D2606  Console Bracket, 206/407 Console		Manufactured	No			110	Each	28.0000	1	5		6/10/06/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				28					
				53196				28					
D2607  Bracket, 206 Console		Manufactured	No			110	Each	9.0000	1	5		6/10/06/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				9					
				50327				9					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

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Work Order ID: 59534

Parent Item: D206-547-043

Parent Item Name: Console High Slope



Comments: IPP Rev: I06-01-05 Removed Packing Kit JLM

Start Date: 6/07/10

Required Date: 6/11/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20470AD3-3  Rivet, Universal Head		Purchased	No			110	Each	8,543.000	8	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST319				8543					
				1065				1435					
				16941				7108					
MS20470AD3-4  Rivet, Universal Head		Purchased	No			100	Each	11,153.00	20	100			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST319				11153					
				111477				8332					
				15541				2821					

Ep 06/06/22

Ep 06/06/18

June 7, 2010 10:33:52 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



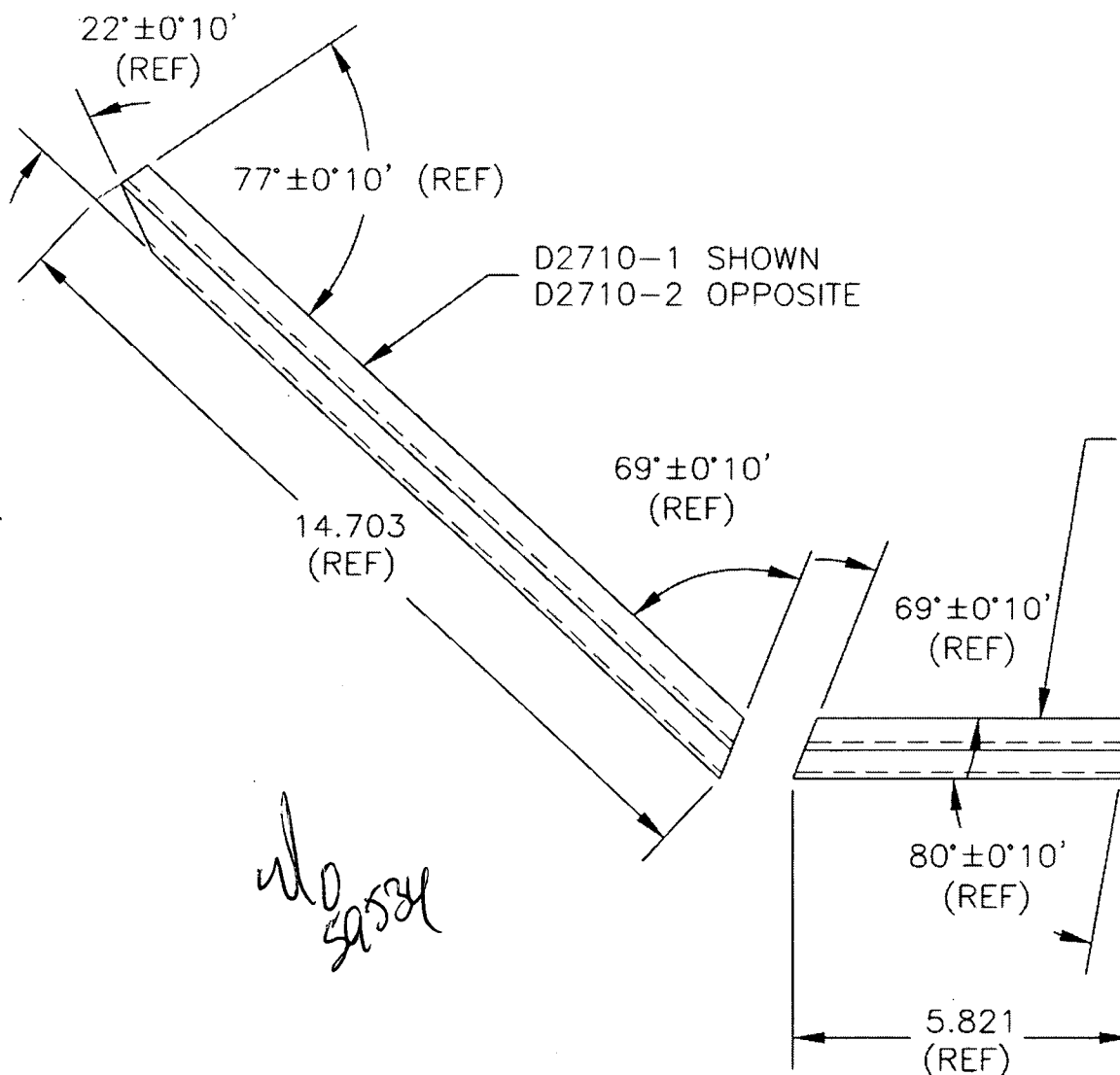
DESIGN BW		DRAWN BY RF		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE		DRAWING NO. D2710	REV. B SHEET 1 OF 1	
DATE 99.02.11		TITLE CONSOLE SIDE RAIL		SCALE 1:3	
A	97.10.25		NEW ISSUE		
B	99.02.11		DELETE WELD, ADD TEMPL. (TSR A1020)		



RELEASED
99.07.05 KE

D2710-1 SHOWN
D2710-2 OPPOSITE

D2710-3 SHOWN
D2710-4 OPPOSITE



MATERIAL: MAKE FROM D2024 EXTRUSION
MAKE PER TEMPLATE # DT8264
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043, -045, -047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
990305 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

4/10
5/15/34

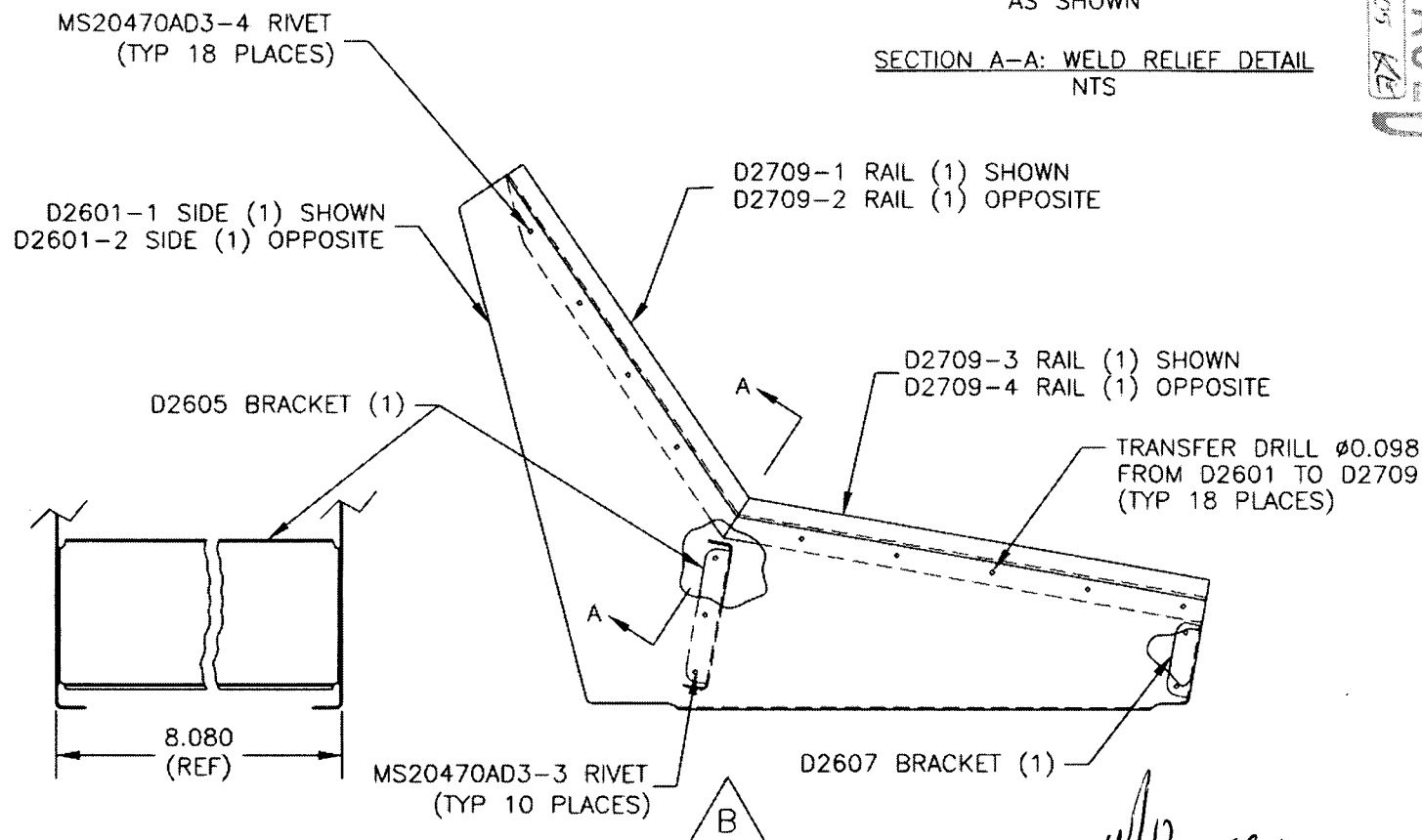
DART

RELEASED
49.0305 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED JP	APPROVED KE	REV. F
DATE 99.02.11	TITLE D206-547	SHEET 2 OF 5
	CONSOLE ASSEMBLY	SCALE 1:4

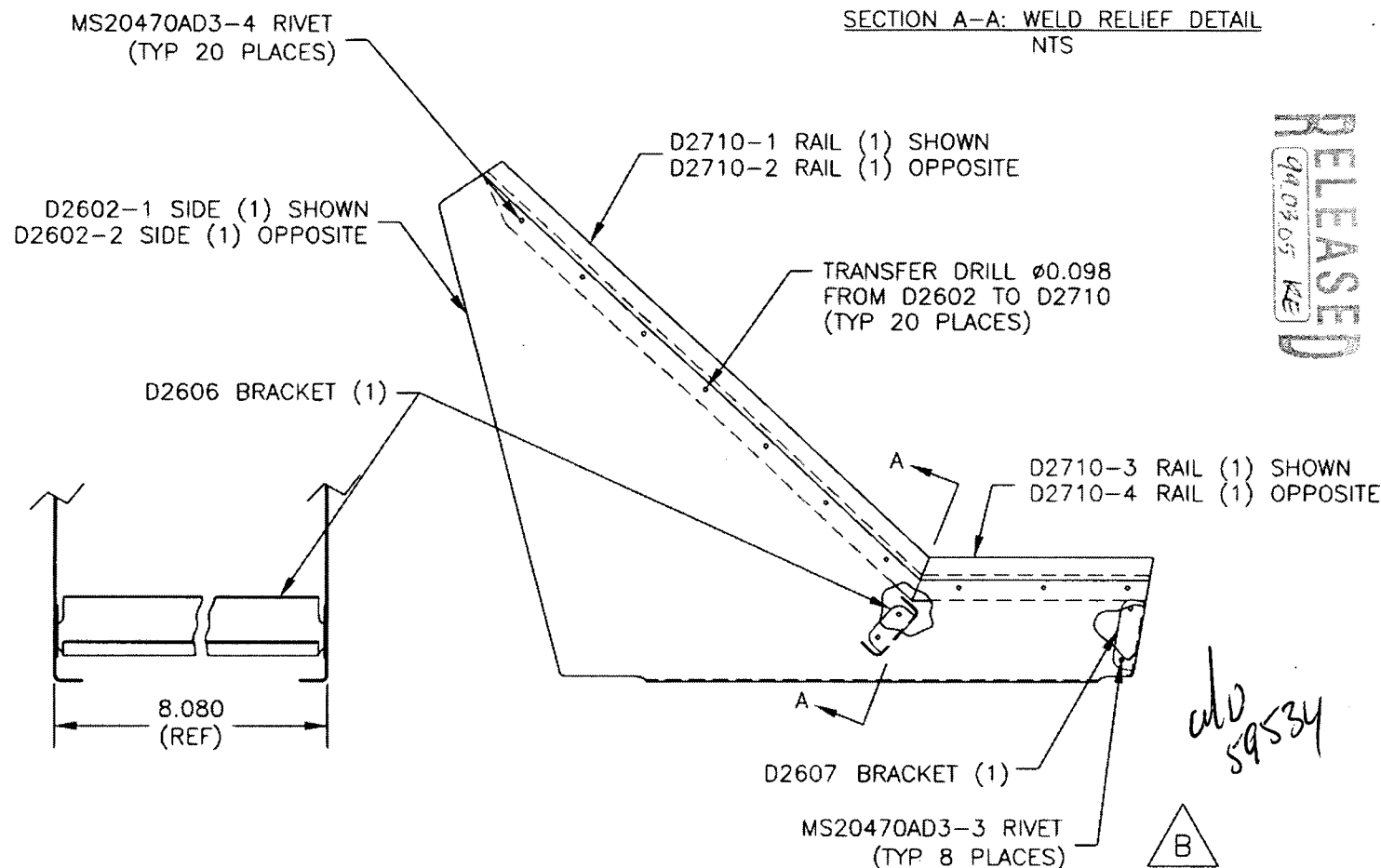


RELEASED
940305 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

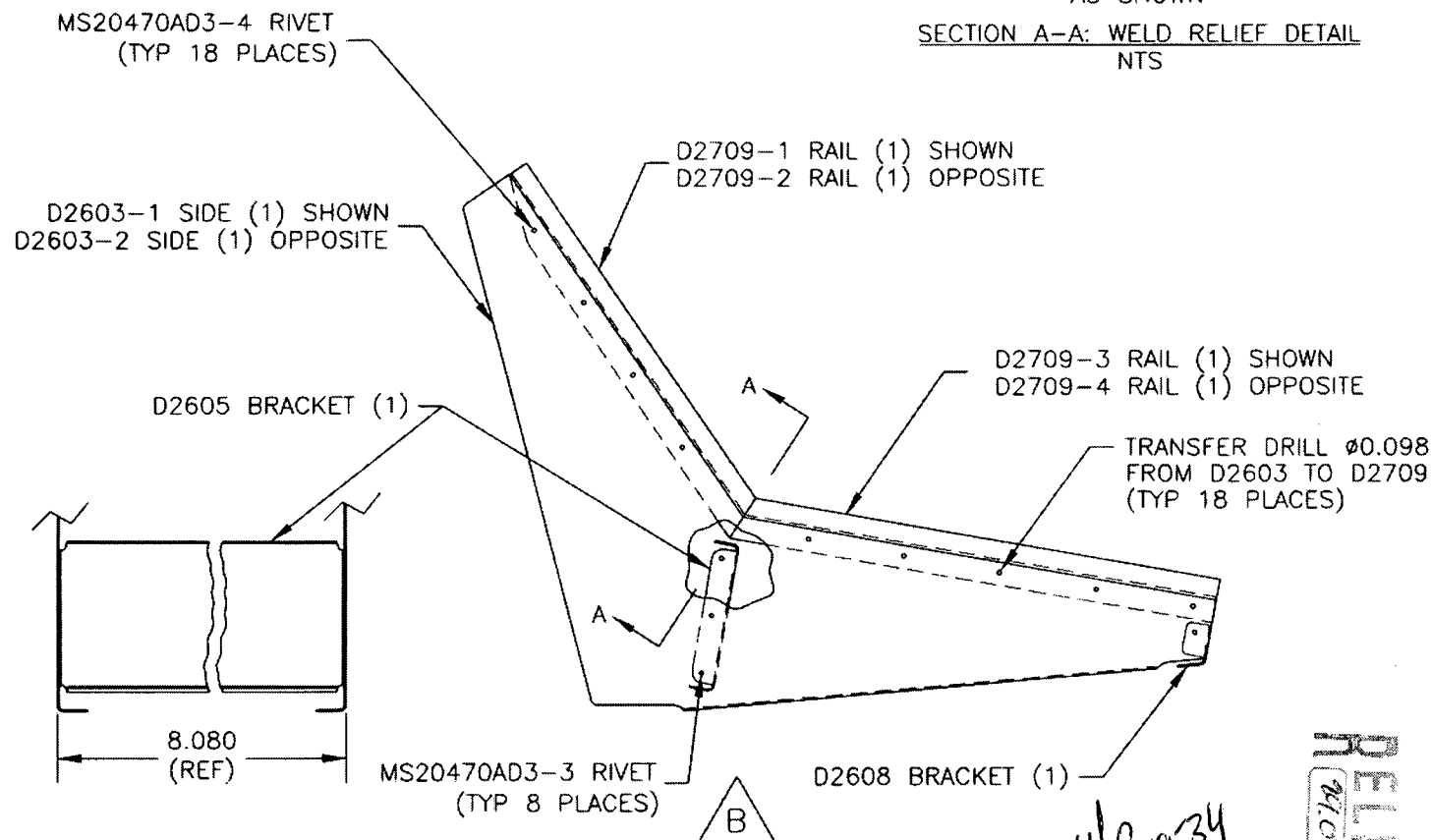
DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SHEET 3 OF 5	SCALE 1:4

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
910305 KE

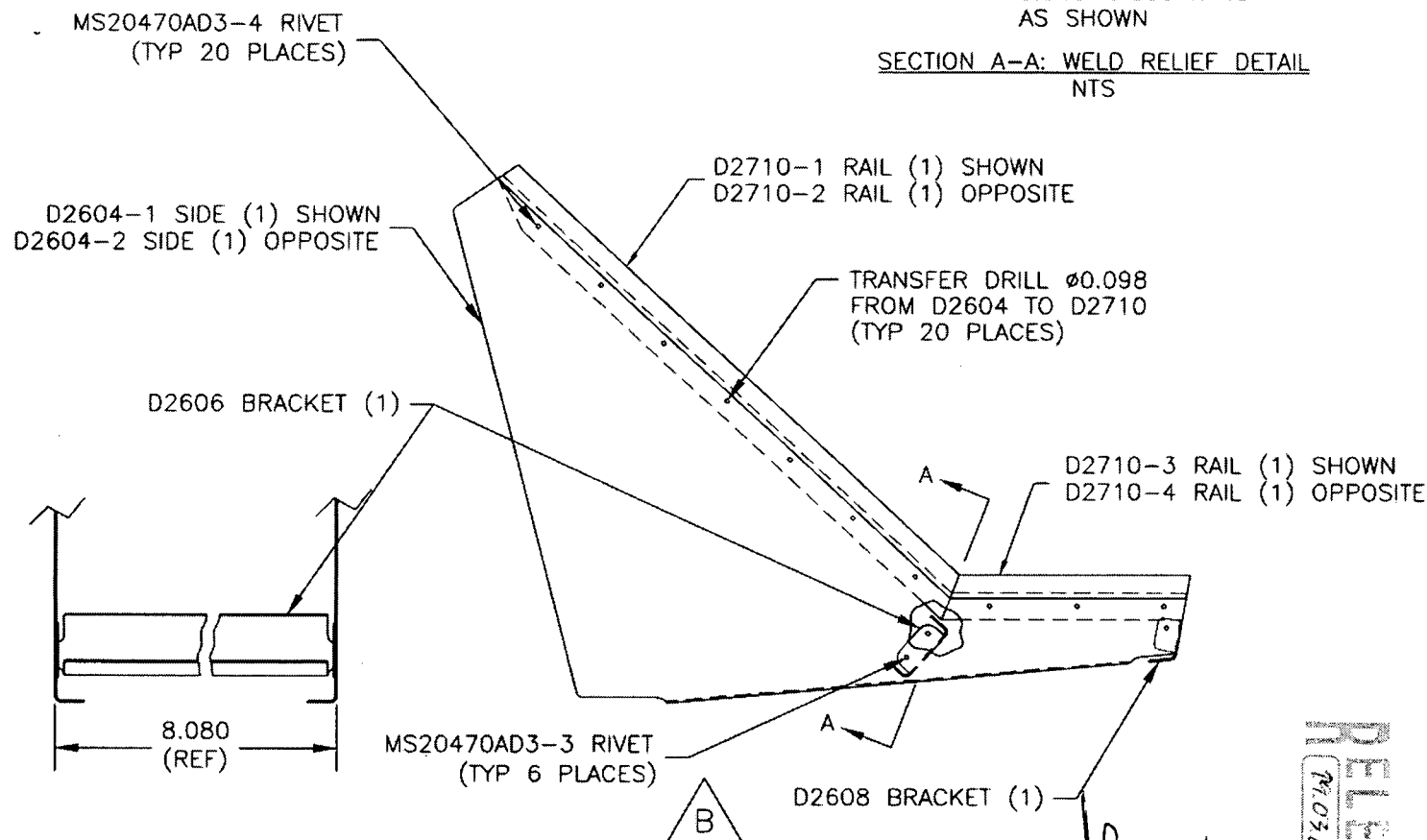
DESIGN Bw	DRAWN BY RF	DART AEROSPACE LTD HANESBURY, ONTARIO, CANADA
CHECKED JP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 4 OF 5 SCALE 1:4

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
170305 KE

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED KE	DRAWING NO. D206-547	REV. F
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SHEET 5 OF 5	SCALE 1:4